

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005729**Date Inspected:** 09-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Imai Jomio**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking, and Deviation Saddles**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Art Peterson was present during the times noted above for observations relative to the work being performed in the Foundry shop at Japan Steel Works.

NDT of Cast Section: West Deviation Saddle Segment W2E3

The QA Inspector observed that the cast saddle segment was being prepared for NDT Inspection by NIS Personnel after the post weld heat treatment (PWHT) was completed.

Cleaning Operation of Cast Section: West Deviation Saddle Segment W2W1

The QA Inspector was informed by JSW Representative Mr. Hideaki Kon that west deviation saddle segment W2W1 was being cleaned prior to NIS NDT personnel performing the NDT of the repaired areas on the stem section.

Repair welding pending on Cast Section: West Deviation Saddle Segment W2W3

The QA Inspector was informed by JSW Representative Mr. Hideaki Kon that no repair welding will be performed on the outside of the trough section on west deviation saddle segment W2W3 on this date.

Repair welding of Cast Section: West Deviation Saddle Segment W2W2

The QA Inspector observed that the following work was in process on the Rib cast sections of west deviation saddle segment W2W2. The JSW welder Mr. Yuuhei Suzuki (ID 03-2302) was performing the buttering /build-up operation on (2) areas of Rib #6 and JSW welder Mr. Hisanori Onodera (ID 93-2272) was performing the buttering / build-up operation on (2) areas of Rib 3 per the SMAW process in the (3G) vertical position. The QC

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Representative present was Mr. Imai Jomio who verified that the welding parameters prior to the start of the welding operation were in compliance with WPS SJ-2941-WP-2. The SMAW welding operations were in process at the end of the QA Inspectors' work shift.

NDT of Cast Section: West Deviation Saddle Segment E2E1

The QA Inspector observed NIS NDT Inspector Mr. Atsui Seino performing liquid penetrant (PT) inspection for information only on the rough machined areas of the ribs and inside of the trough sections.

Shaping of Cast Section: East Deviation Saddle Segment E2W1

The QA Inspector observed JSW personnel performing the shaping (scarfing) operation on the outside of the trough section where the bottom of the trough transitions to the rib for profiling to the proper radius. The shaping operation was in process at the end of the QA Inspectors' work shift.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 510 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Peterson, Art	Quality Assurance Inspector
Reviewed By:	Lanz, Joe	QA Reviewer
